

Date: Wednesday, 3/14/2007 3:30:31 PM
User: Kim Johnston

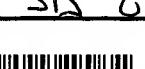
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BELL CRANK		
Job Number	: 31220					
Estimate Number	: 11967					
P.O. Number	: N/A		Part Number	: D2056		
This Issue	: 3/14/2007	S.O. No.	: N/A	Drawing Number	: D2056 REV B2	
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: 3/14/2007	Type	: MACHINED PARTS	Drawing Revision	: B2	
Previous Run	: 26524		Material	: N/A		
Written By	:		Due Date	: 3/26/2007		
Checked & Approved By	: 807.03.15		Qty:	30	Um:	Each
Comment	Est.	E 02.04.04	Added Rev.B2 NG			

Additional Product

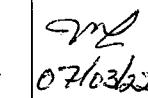
Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25"
		
		
	Comment: Qty.: 0.2494 f(s)/Unit Total : 7.4813 f(s) 6061-T6 Bar 1.25 x 1.25" Material: 6061-T6, 1.250" x 1.250"	M103220 (3 parts) Batch: M103629 SD 07.03.20 30
2.0	BAND SAW	BAND SAW
		
		
	Comment: BAND SAW Cut blanks 2.80" long	SD 07.03.20 30
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
		
	Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2056 Tumble Deburr any rough edges after tumbling	On/SD 07.03.20 30
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	On/SD 07.03.21 30
5.0	QC8	SECOND CHECK
		
		
	Comment: SECOND CHECK	T1 07.03.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/03/22
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/22	3	1 piece scrap, pop out of the vise.		destroy and replace	 07/03/22	 07/03/22	 07/03/22	 07/03/22

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BELL CRANK

Job Number: 31220

Part Number: D2056

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

u

07-03-26 (30)

7.0 POWDER COATING

POWDER COATING



M100700

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

u

07-03-27 (30)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/3/28 (30)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/3/28 (30)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/29 (30)

Job Completion



u 07-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

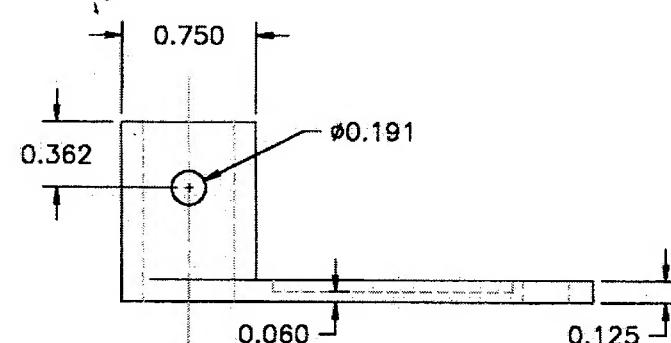
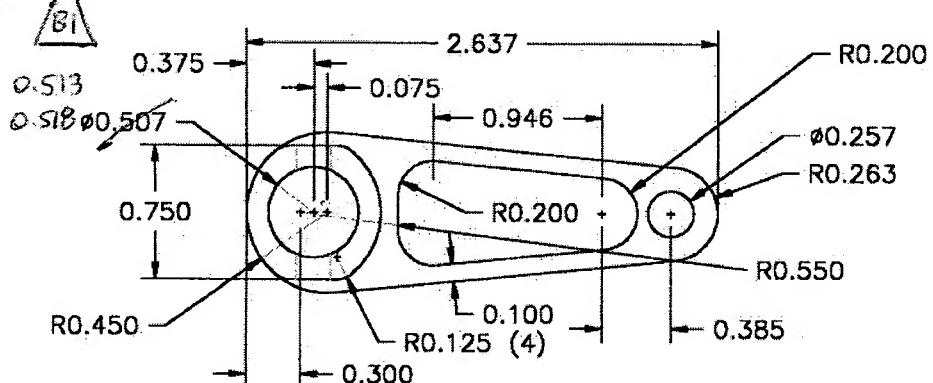
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**

44-0429 PE

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
B	B. WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA	SHEET 1 OF 1
CHECKED	APPROVED	DRAWING NO.	SCALE
<i>Bi</i>	<i>KE</i>	D2056	1:1
DATE		TITLE	
92:03:13		BELL CRANK	
B	95:11:02	RE-DESIGN	
B1	01.08.04	MODIFY HOLE SIZE, ADD P/C OPTIM	
B2	01.12.10	ADD NOTE ON TOLERANCES	



Bi ACID ETCH & ANODING PER
DART QSI 005 4.1
POWDER COAT BLACK STANDARD
(4.3.5.7) PER DART
QSI 005 4.3

B2

MATERIAL: 6061-T6 (QQ-A-225/8)
FINISH: ANODIZE (BLACK) OR
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

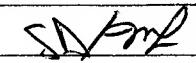
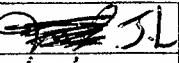
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31220

DART AEROSPACE LTD		Work Order:	31220
Description:	12056	Part Number:	12056
Inspection Dwg:	Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 2.637	$\pm .010$	2.634	/			
B .375	$\pm .016$.376	/			
C $\varnothing .513^{.518}$	N/A	.515	/			
D .750	$\pm .010$.749	/			
E .100	$\pm .010$.104	/			
F $\varnothing .257$	$\pm .006$.258	/			
G						
H .750	$\pm .020$.750	/			
I .362	$\pm .010$.371	/			
J $\varnothing .191$	$\pm .005$.192	-			
K .060	$\pm .010$.061	/			
L .125	$\pm .010$.127	/			
M						
N .750	$\pm .010$.749	/			
O 1.000	$\pm .010$	1.003	/			
P .700	$\pm .010$.896	/			
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	07.03.20	Date:	07/03/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	